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D4753-1
Job Sheet 181263



Part No: D4753-1

Job Qty: 30 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		8/31/18	0.00	0.00	Start Up Waterjet		SE 18/08/18
100	Waterjet	30 pcs		8/31/18	0.00	0.90	Waterjet1		SE 18/08/18
110	QC	30 pcs		8/31/18	0.00	0.00	QC2 Waterjet-1		SE 18/08/18
120	CNC Vertical Machining	30 pcs		8/31/18	0.02	2.16	HAAS1-5		DTP 18/08/18
140	QC	30 pcs		8/31/18	0.00	0.00	QC8		MM 18/08/18
150	Small Fab	30 pcs		8/31/18	0.00	0.36	Small Fab-7		ES DAS 38
160	QC	30 pcs		8/31/18	0.00	0.00	QC5		38
170	HandFinish	30 pcs		8/31/18	0.00	0.25	HandFinish1		D.R. 18/08/18
180	QC	30 pcs		8/31/18	0.00	0.00	QC7-4		AUG 16 2018 38
190	Packaging	30 pcs		8/31/18	0.00	0.00	Packaging3-2	66001	21 AUG 20 2018 9-89
200	QC21-SA	30 Ea		8/31/18	0.00	0.00	QC21		21 AUG 20 2018

Part Op 100 - 1-Cut as per Dwg D4753 Dwg Rev: A Prog Rev: A ***.758" DIA HOLE TO BE OPENED TO FIN
Descriptions: SIZE BY SKID DEPARTMENT UPON INSTALLATION** 3- Debur if necessary
120 - Machine as per Folio FB163 and Dwg D3506 FOLIO REV: _____ DWG REV: _____ ***.758" DIA HOLE
TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT UPON INSTALLATION**
150 - C'sink as per Dwg D4753 (On Flat side)
190 - LOCATION : LG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	.4140 sf (.0138 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	0	61	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128Inches + 0.005 - 0.001	0.133 0.127	0.128	Diameter
2	Doubler	0.500Inches ± 0.010	0.510 0.490	0.501	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																	
Description Work Order Deviation Container No: S098621 Part: D4753-1 Job No: 181263 Serial No/Batch: S098621 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 08/02/18																					
<table style="width:100%; border: none;"> <tr> <td style="width:25%; border: none;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:25%; border: none;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:25%; border: none;"> Pressure/Forced ☐ Bending ☐ Centre Not Conce ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:25%; border: none;"> Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> <tr> <td colspan="4" style="border: none;"> OTHER : _____ </td> </tr> </table>					Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Conce ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	OTHER : _____												
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OTHER : _____																					

3	Doubler	1.000Inches ± 0.010	1.010 0.990	1,002
4	Doubler	0.750Inches ± 0.010	0.760 0.740	0,753
5	Doubler	1.500Inches ± 0.010	1.510 1.490	1,501
6	Doubler	2.000Inches ± 0.010	2.010 1.990	2,002
7	Doubler	0.126Inches ± 0.010	0.136 0.116	0,128
8	Doubler	3.540Inches $+ 0.012$ $- 0.001$	3.552 3.539	3,542 Diameter
9	Doubler	0.126Inches ± 0.010	0.136 0.116	0,125

DSR 12/08/11

Plex 7/24/18 10:01 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					